

Date: Monday, 1/7/2008 11:13:11 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36587
Estimate Number : 12277
P.O. Number :
This Issue : 1/7/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : MACHINED PARTS
Previous Run : 34356
Written By :
Checked & Approved By :
Comment : Est. F 02.09.19 Re-format; Incorporated D2065 KJ

Drawing Name : SINGLE MIRROR ASSEMBLY
Part Number : D206558041
Drawing Number : D206-558 / D2065
Project Number : N/A
Drawing Revision : C / B1
Material :
Due Date : 1/14/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D206-558-041 CHG005

2.0 M304TR0500W035

304 RD Tube 500 x .035W



Comment: Qty.: 1.7500 f(s)/Unit Total : 17.5004 f(s)

304 RD Tube .500 x .035W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W035)

Identify as D2065.

Note: 1 end only

Batch M104593

3.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall AISI

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut to length as per Dwg D2065

Bend as per Dwg D2065 and template D2065T1

Flatten the end on Hydraulic press using Dt 8545

Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.

Deburr.

mf 08-01-08

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Seq. #:

Machine Or Operation:

Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

↓ 08/01/08 (+12)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 100700

BR 08-01-11

(12)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/01/11

(12X)

8.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number Description Batch

1 D2011-101 Mirror

1335536

SP

9.0

D2052

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

2 D2052 Bracket

1217500

SP

10.0

D2054

Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing - Delrin

Pick:

Qty Part Number Description Batch

2 D2054 Bushing

123129

SP

11.0

D2055

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8/1/11 SP (12X)

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Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D2055 Clamp

12.0

D2056

Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bell Crank Assembly

Pick:

Qty Part Number Description Batch

1 D2056 Bellcrank

1531220

SP

13.0

D2057

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Plug

Pick:

Qty Part Number Description Batch

1 D2057 Plug

1531366

SP

14.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10

Washer

1105792

SP

15.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21042L3

Nut

1105558

SP

or MS21042-3

16.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Screw

Pick:

Qty Part Number Description Batch

2 MS27039-1-18 Screw

1102339

8/1/11 SP

(12X)

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Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-558

mf

08-01-14

(11)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/01/14

(XII)

19.0

D2053

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

1 D2053

Description Batch

Bracket

B31700

Connector

PC

8/01/14

(12)

20.0

D2067

Connector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Connector

Pick: Packing Kit

Qty Part Number

1 D2067

Description Batch

Connector

31221 9X

Cable Assembly

B36622 (3X)

PC 8/1/14

non 9

PC

21.0

D2071

Cable Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty Part Number

1 D2071

Description Batch

Cable

B31222 1X

B36623 1X / 8/1/14

B35866 10X

PC

22.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

4 AN3-4A

Description Batch

Bolt

M103641

PC 8/1/14 (12)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN5261032R9

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526-1032R9 Screw M101189
or AN526C1032R9

PO 8/10/14 (12)

24.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch: M105558

PO (12)

25.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer M104374

PO (12)

26.0

MS21919DG5

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp 17864 14X
or MS21919WDG5 M105431 10X

PO 8/10/14 (12)

27.0

MS354899

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet 9619

PO 8/10/14 (12)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/21/11 (11)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8/21/11 50 (1/2)

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/28/12 (11)

Job Completion



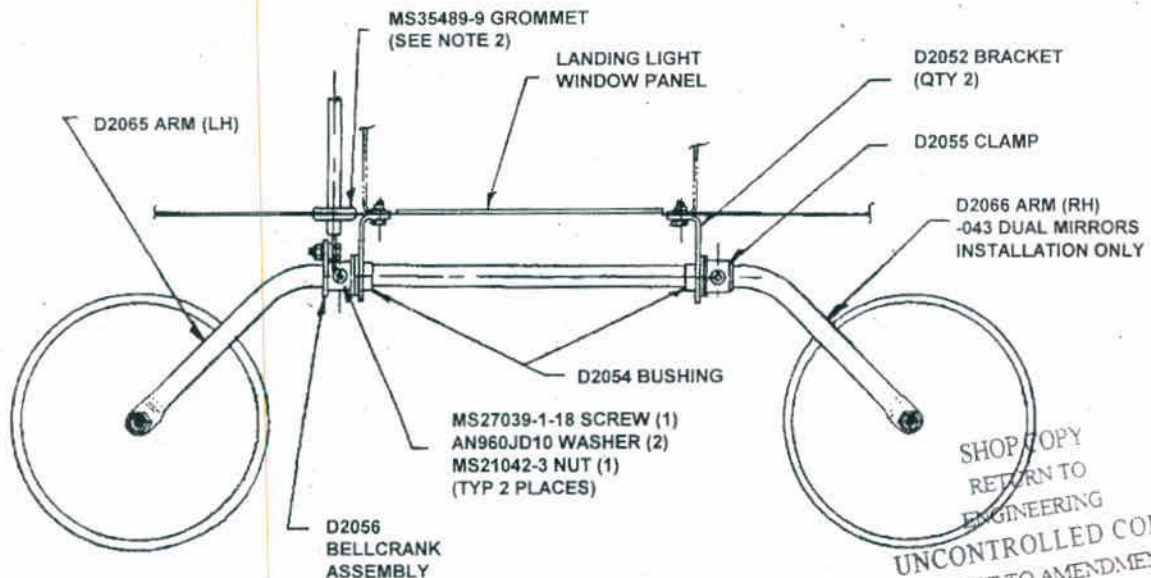
2/28/12 (11)

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3.0 CARGO MIRROR INSTALLATION

Install the Cargo Mirror as follows:

1. Install D206-558-041/-043 cargo mirror assembly using AN3-4A bolts and AN960JD10L washers. Pickup existing anchor nuts in 4 places.
2. Install D2067 connector onto D2056 bellcrank assembly to locate hole for MS35489-9 grommet. With the mirror in the deployed position, mark and drill $\varnothing 0.125$ " (3.2mm) hole in landing light window panel where the grommet should be located. Open pilot hole to $\varnothing 0.563$ " (14.3mm). Install grommet.
3. Install D2053 bracket using AN526-1032R9 screws. Pickup on existing anchor nuts.
4. Position D2071 cable as shown. Install MS21919DG5 clamps using AN526-1032R9 screws where required. Pickup existing rivnuts or anchor nuts if available.
5. Install D2071 control cable using D2067 connector. Connector should rotate freely in bellcrank when MS21042-3 nut is torqued and cable clamped



**Figure 2: – View A: Looking Aft.
(D206-558-043 Mirror Shown)**

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Revision: C

Date: 01.10.03

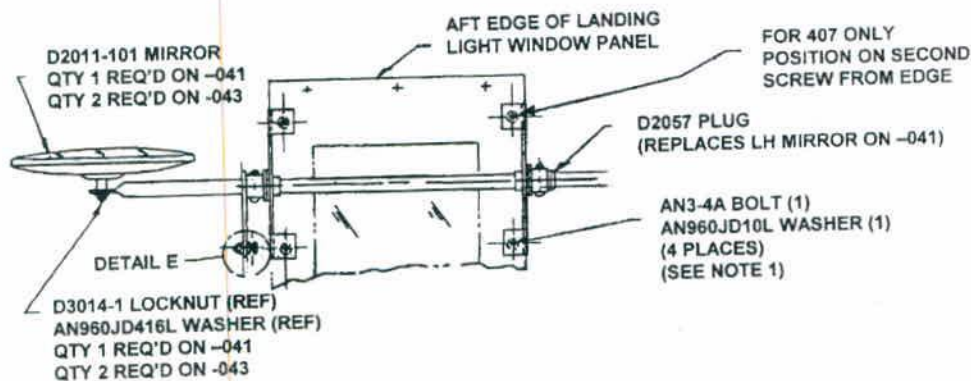


Figure 3: - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

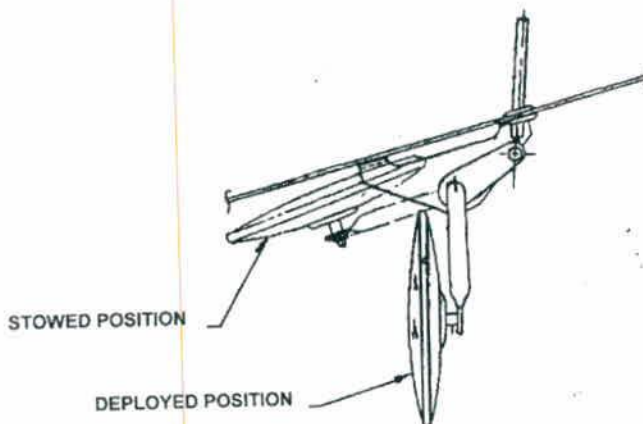


Figure 4: - Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

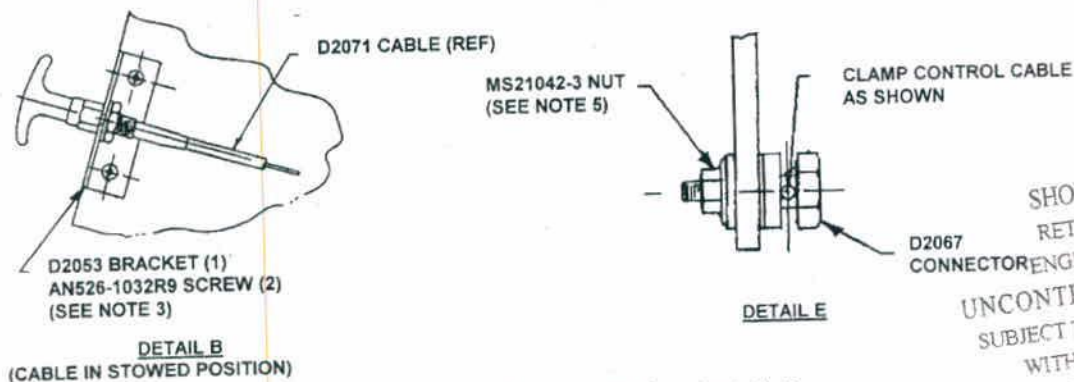


Figure 5: - Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)